

Monday, 2/4/2008 11:22:13 AM
Kim Johnston

Process Sheet

Cust: : CU-DAR001 Dart Helicopters Services Drawing Name : HELI UTILITY BASKET
Job Number : 37144
Estimate Number : 10819
P.O. Number :
This Issue : 2/4/2008 S.O. No. :
Print Rev. : NC Part Number : D130701041
Drawing Number : IIN D130-701 REV B
First Issue : / / Type : LARGE FAB ASSY Project Number : N/A
Drawing Revision : N/A
Previous Run : 31096 Material :
Due Date : 2/12/2008 Qty: 1 Um: Each
Written By :
Checked & Approved By : 08 02 04
Comment : Est Rev:A 02.12.04 New issue KJ/RF
Est Rev:B 07-06-28 As per Rev B JLM

Additional Product

Job Number:



Seq. # Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D130-701-041 CHG003

08.02.04

2.0 37144A 350/212/130 BASKET LID



Comment: Sub-Component 350/212/130 BASKET LID

37144A MF

3.0 37144B BASKET BASE ASSEMBLY EC 130



Comment: Sub-Component BASKET BASE ASSEMBLY EC 130

37144B MF 08-02-20

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

5.0 D2022101 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2022-101 Spacer

1533985 SP

6.0 D2258220 Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2258-220 Label

1530810 8/2/20 SP (1x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/4/2008 11:22:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET

Job Number: 37144

Part Number: D130701041

Job Number:



Seq. #:

Machine Or Operation:

Description:

7.0

D2332041

Lid Prop Assembly 6.69"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch
1 D2332-041 Prop Assy 1335718

SP

8.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch
1 D2530 Handle Assy 1335357

SP

9.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch
2 D2535 Spring 1334188 36397

SP

10.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch
2 D2537 Bushing 34788 1336397

SP

11.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch
2 D2931 Bumper 1321139

SP

12.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch
2 AN3-16A Bolt 1104603

8/2/20 SP

(1x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: HELI UTILITY BASKET

Job Number: 37144

Part Number: D130701041

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN4-7A Bolt M102140

SP

14.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 AN4-22A Bolt M104737

SP

15.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 AN4-24A Bolt M104547

SP

16.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN5-17A Bolt M104625

SP

17.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD416 Washer M106277

SP

18.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD416L Washer M106785

8/2/20 SP

(1x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: HELI UTILITY BASKET

Job Number: 37144

Part Number: D130701041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

19.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD516 Washer M106654

SP

20.0	AN960JD8	Washer
------	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD8 Washer M106112

SP

21.0	AN9704	Washer
------	--------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4 Washer M105442

SP

22.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) M106242

SP

23.0	MS21042L4	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4) M105938

8/2/20 SP (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

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Drawing Name: HELI UTILITY BASKET

Job Number: 37144

Part Number: D130701041

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

4 MS21042L5

Nut (or -5)

M106277

54

25.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

2 MS20600AD4W3 Rivet

M18071

8/2/20 50

(12)

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg IIN-D130-701

MF 08-02-20

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10002.20

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

29.0

D3173041

Beam Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D3173-041

Beam Assembly

B32151

B25024

54

30.0

D3177041

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

B24923

8/2/20 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

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Drawing Name: HELI UTILITY BASKET

Job Number: 37144

Part Number: D130701041

Job Number:



Seq. #:

Machine Or Operation:

Description:

1 D3177-041 Bracket Assembly

31.0

D3177043

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3177-043 Bracket Assembly

~~1327158~~

24883

24883

50

32.0

D3180041

Strut Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3180-041 Strut Assembly

1337505

8/2/21 50

33.0

D31811

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3181-1 Bushing

M18170

50

34.0

AN47A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN4-7A Bolt

M102140

50

35.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-12A Bolt

M10543

50

36.0

AN510A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN5-10A Bolt

M106579

8/2/20 50

(1x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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User: Kim Johnston

Process Sheet

Customer: GU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET

Job Number: 37144

Part Number: D130701041

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

AN523A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN5-23A Bolt

M19278

SQ

38.0

AN960JD416

Washer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

5 AN960JD416 Washer

M106277

SQ

39.0

AN960JD516

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD516 Washer

M106654

SQ

40.0

MS21042L4

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

3 MS21042L4 Nut (or -4)

M105938

SQ

41.0

MS21042L5

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS21042L5 Nut (or -5)

M106277

8/2/20 SQ (12)

42.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET

Job Number: 37144

Part Number: D130701041

Job Number:



Seq. #:

Machine Or Operation:

Description :

43.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D130-701-041

Location:

PPP Rev:

PC 8/21-11

44.0

QC21

FINAL INSPECTION/W/O RELEASE



08.02.21
[Signature]

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



CU D. 02/21

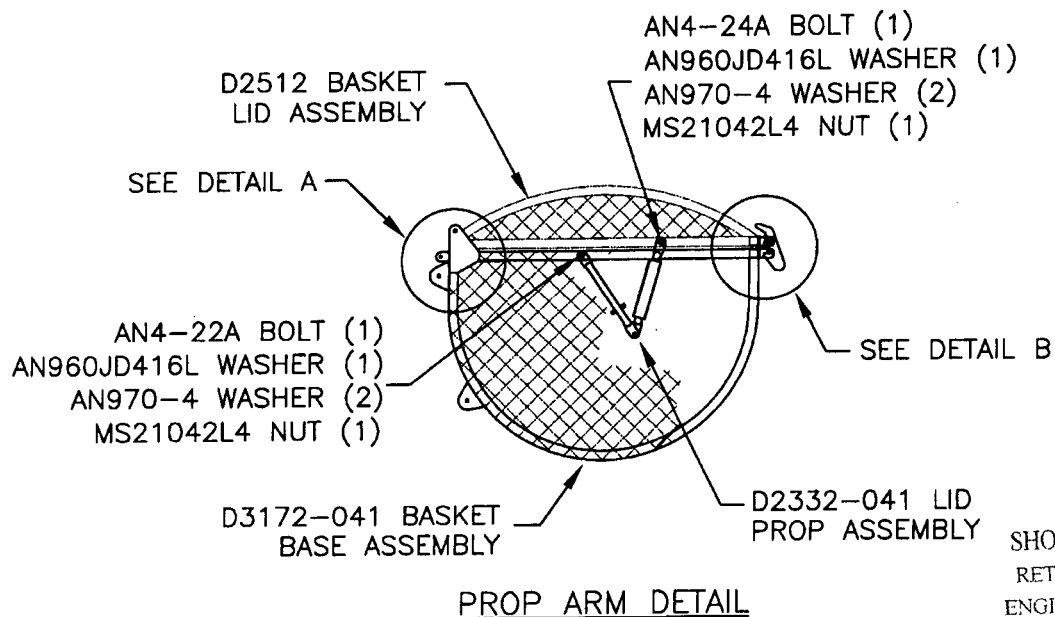
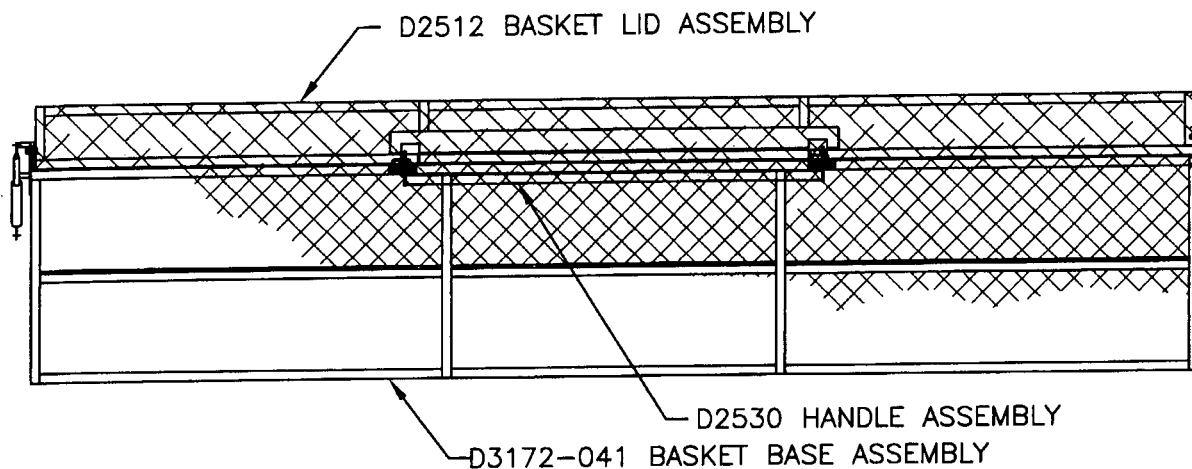
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



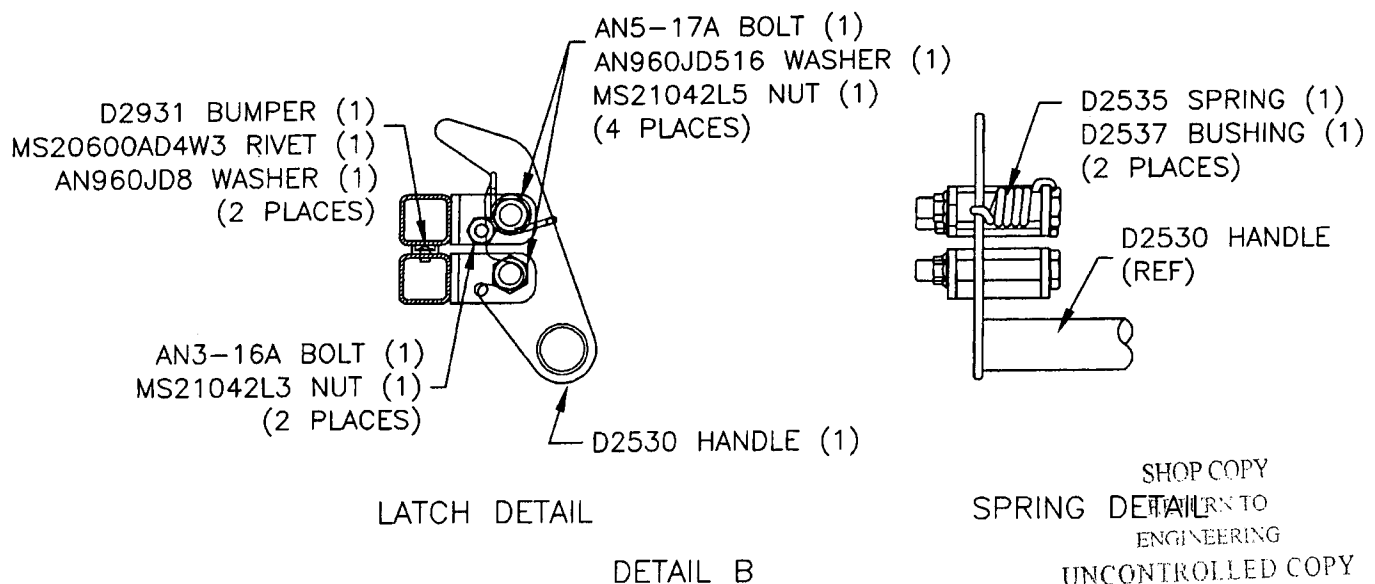
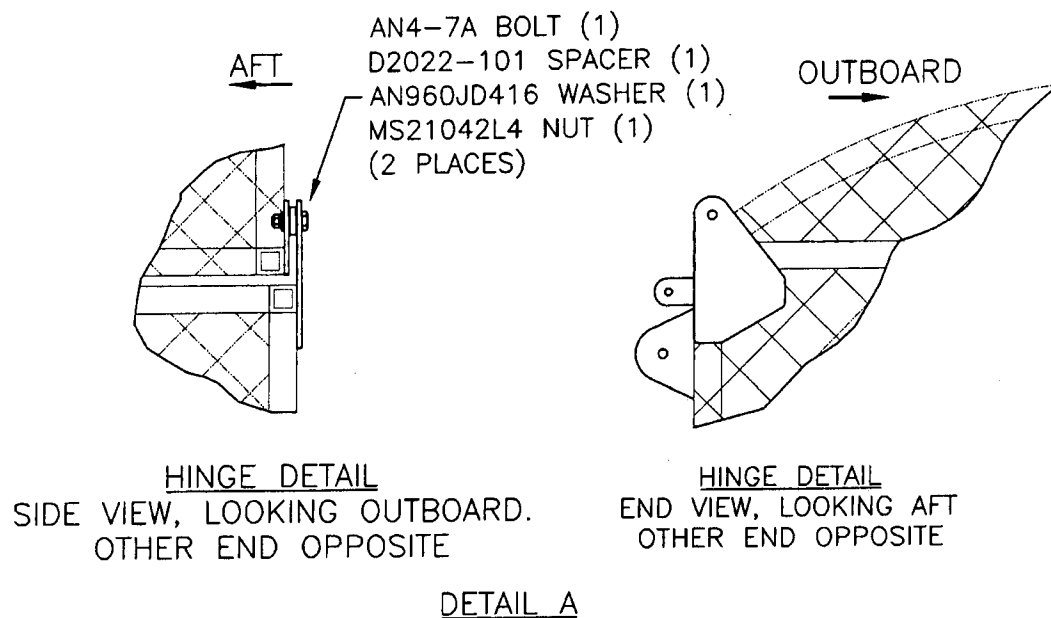
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WORK ORDER
NO. 37144

Figure 6 – Basket Replacement Parts

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Revision: **B**

Date: 03.01.07



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NO. 37144

Figure 7 - Basket Replacement Parts continued

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D130-701-041 (LH installation)	120 lb 54 kg	- 47.4 in - 1.20 m	- 5688 in-lb - 64.8 m-k-g	133.9 in 3.40 m	16068 in-lb 183.6 m-k-g
D130-701-041 (RH installation)	120 lb 54 kg	+ 47.4 in + 1.20 m	+ 5688 in-lb + 64.8 m-k-g	133.9 in 3.40 m	16068 in-lb 183.6 m-k-g
2 x D130-701-041 (LH & RH installation)	224 lb 102 kg	0.0 in 0.00 m	0 in-lb 0.0 m-k-g	133.9 in 3.40 m	29994 m-k-g 346.8 m-k-g

5. PARTS LIST

Qty -041	Part Number	Description
X	D130-701-041	HELI-UTILITY-BASKET
2	D2022-101	SPACER
1	D2258-220	LABEL
1	D2332-041	PROP ASSEMBLY
1	D2512	BASKET LID ASSEMBLY
1	D2530	HANDLE ASSEMBLY
2	D2535	SPRING
2	D2537	BUSHING
2	D2931	BUMPER
1	D3172-041	BASKET BASE ASSEMBLY
2	D3173-041	BEAM ASSEMBLY
1	D3177-041	BRACKET ASSEMBLY
1	D3177-043	BRACKET ASSEMBLY
1	D3180-041	STRUT ASSEMBLY
1	D3181-1	BUSHING
2	AN3-16A	BOLT
2	AN4-12A	BOLT
1	AN4-22A	BOLT
1	AN4-24A	BOLT
3	AN4-7A	BOLT
4	AN5-10A	BOLT
4	AN5-17A	BOLT
2	AN5-23A	BOLT
7	AN960JD416	WASHER
2	AN960JD416L	WASHER
16	AN960JD516	WASHER
2	AN960JD8	WASHER
4	AN970-4	WASHER
2	MS20600AD4W3	RIVET
2	MS21042L3	NUT (OR MS21042-3)
7	MS21042L4	NUT (OR MS21042-4)
10	MS21042L5	NUT (OR MS21042-5)

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NO. 37144

7

Date: Monday, 2/4/2008 11:22:22 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350/212/130 BASKET LID
Job Number	: 37144A		
Estimate Number	: 10193		
P.O. Number	:	Part Number	: D2512
This Issue	: 2/4/2008 S.O. No. :	Drawing Number	: D2512 REV D2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: D2
Previous Run	: 36820A	Material	:
Written By	:	Due Date	: 2/12/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>AD 08 02 04</u>		
Comment	: Rev Est: M 03.01.31 Added D2012-117 for D130-701-041 KJ/RF Est Rev: N 06.04.05 Added level 21 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
-----	----------------	--------------------------



Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)

Pick:

3/4"x3/4" 304/316 SS tube .063" wall

Batch: M106909

FC 08/02/12

2.0	D31663	Basket Hoop
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D3166-3 Basket Hoop

B36693

PD 08-02-12

3.0	D2506	Placard
-----	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2506 Label Plate

B35585

PD 08-02-12

4.0	D23271	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 D2327-1 Bushing

B31693

AD 08-02-12

W/O:		WORK ORDER CHANGES					
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 37144A

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22321

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

2 D2232-1 Hinge plate

Batch

B31608 -> 1*

B35684 -> 1*

PD 08-02-12

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

2 D2581 Mounting Bracket

Batch

B36481

PD 08-02-12

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number Description

18 sf M304EX0.75-16F Expanded Metal

Batch

M107036

PD 08-02-15 ①

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

FC 08/02/12

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

PD 08-02-19 ①

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

12 08/02/19 ①

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

12 08/02/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 37144A

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

POWDER COATING

POWDER COATING



M107005



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

91 08.02.20

(X1)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



BACK M106925



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: M106894 BR 08-02-20

①

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 08-02-20

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

MF 08-02-20

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.02.21
H

Job Completion



Li 08-02-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

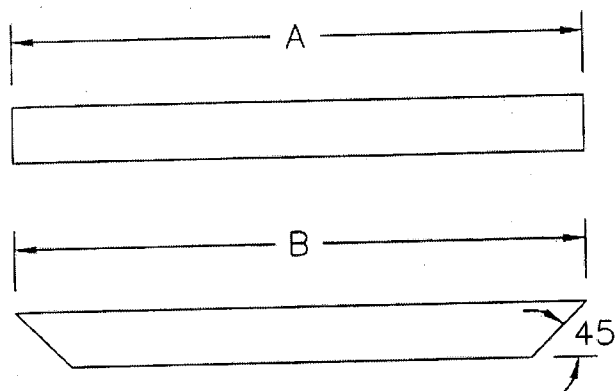


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CHECKED #	APPROVED #	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	
A		95.11.21	NEW ISSUE
B		96.05.24	ADDED LATCH CHANNEL & LABEL PLATE
C		99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074
D		01.04.19	CHANGE HINGE
D1		UP 03.01.20	ADD D2012-117 FOR D130-701-041
D2		UP 04.07.20	TACK WELD ANT-SKID AREA

RELEASED
01.04.27 #

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



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D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

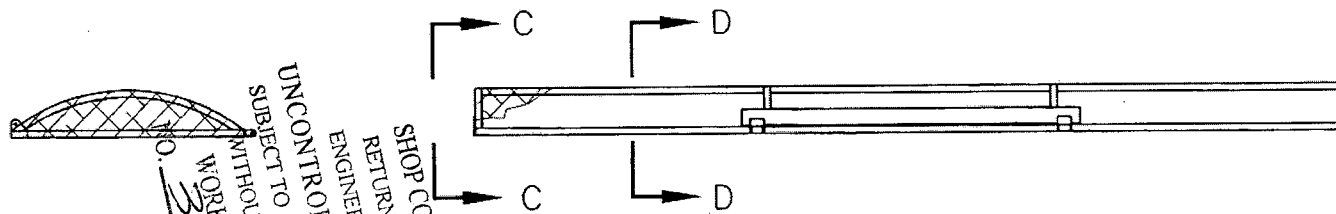
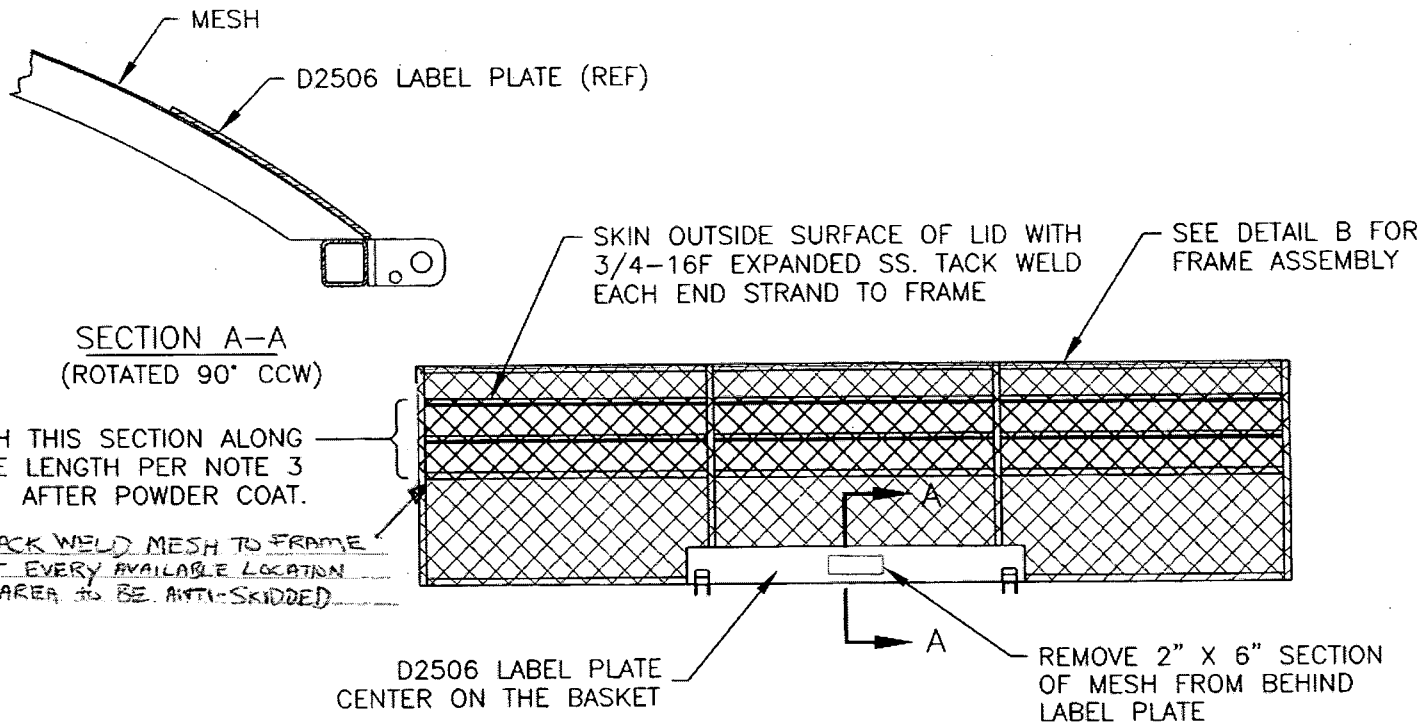
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				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2512
DATE	01.04.19			TITLE BASKET LID ASSEMBLY (350/212)
				REV. D
				SHEET 2 OF 4
				SCALE 1:20



- D2512 BASKET LID ASSEMBLY**
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
 - 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES

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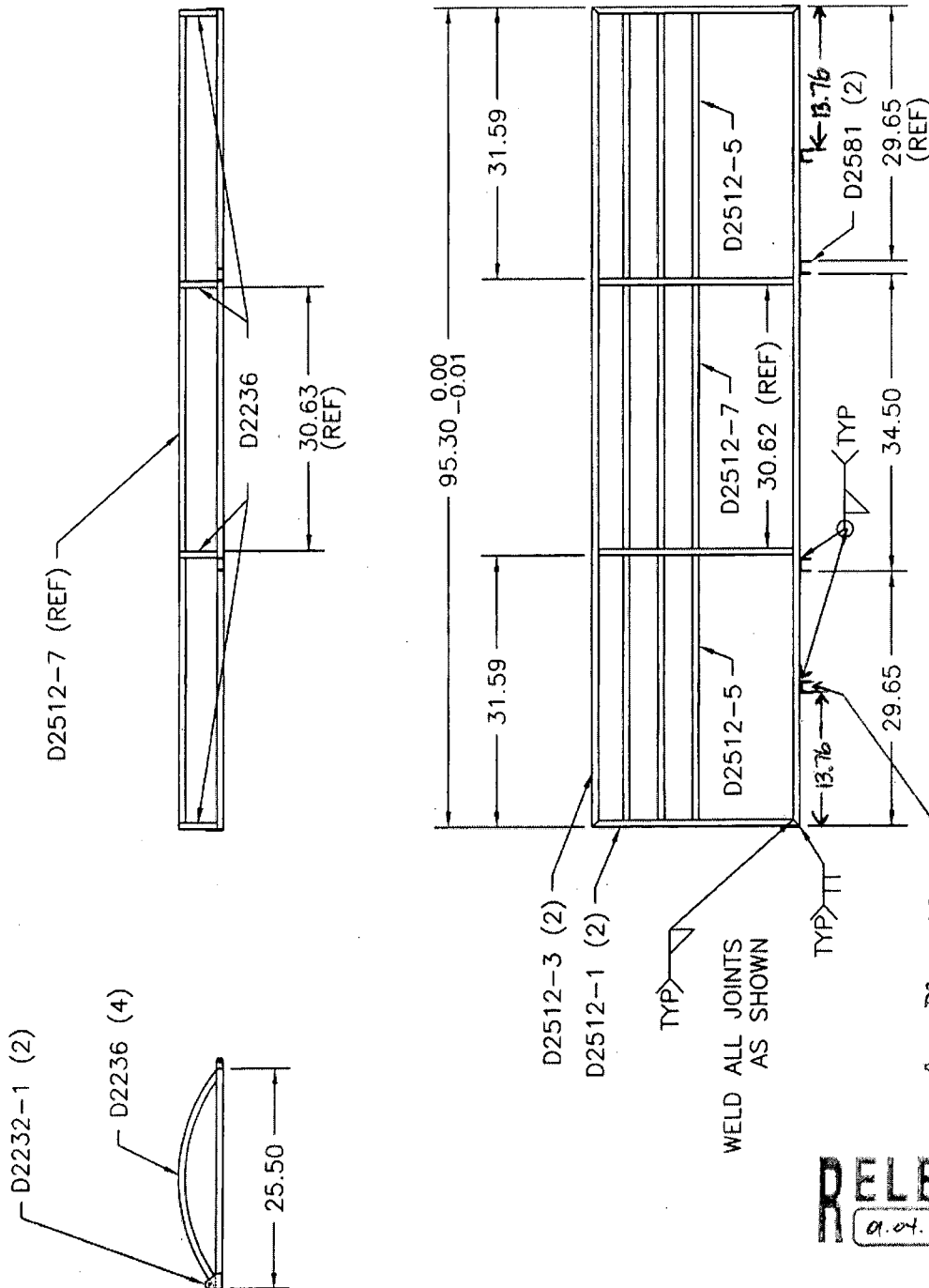
WORK ORDER
NO. 371444A

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01.04.23

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CHECKED A	APPROVED A	DRAWING NO. D2512	REV. D SHEET 3 OF 4
DATE 01.04.19	TITLE BASKET LID ASSEMBLY (350/212)		SCALE 1:20



DETAIL B
FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

DI
D2012-117 CLEVIS
ADD FOR D2012-701-041
2 PLATES
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WITHOUT NOTICE
WORK ORDER
NO. 37144A

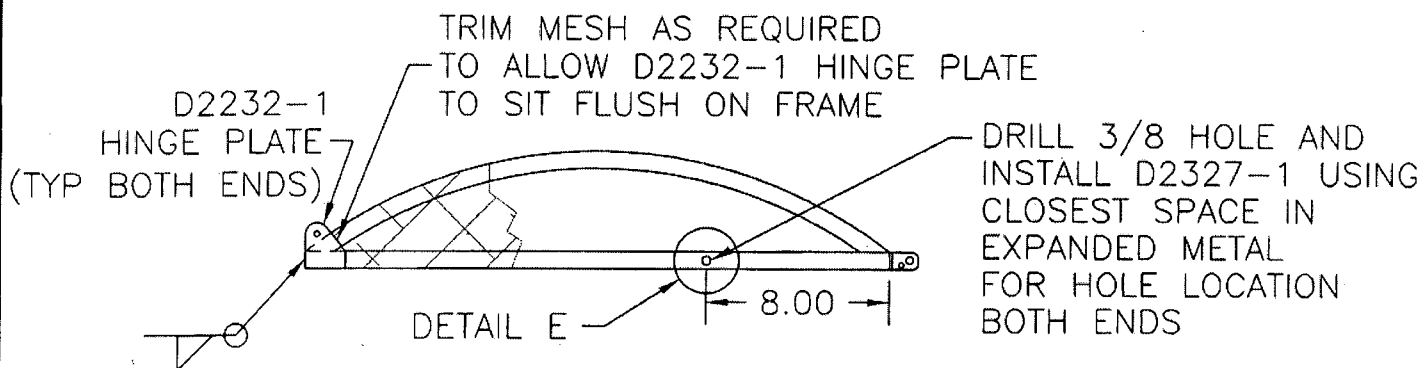
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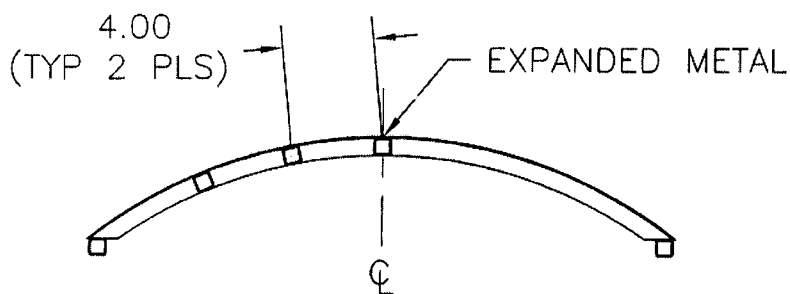
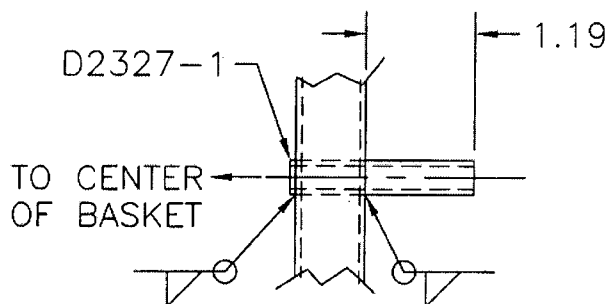
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CHECKED #	APPROVED #	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:8



SECTION C-C SIMILIAR BOTH END RIBS



SECTION D-D SAME BOTH CENTER RIBS

DETAIL E

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Date: Monday, 2/4/2008 11:22:32 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BASKET BASE ASSEMBLY EC 130
 Job Number : 37144B
 Estimate Number : 10814
 P.O. Number :
 This Issue : 2/4/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D3172041
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D3172 REV B
 Previous Run : 31096B Material :
 Due Date : 2/12/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev B 04.01.05 Added Step 5 inspection KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D31661 Basket Hoop



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty 4 D3166-1 Basket Hoop Batch: B36457

PD 08-02-12

2.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 42.0000 f(s)/Unit Total : 42.0000 f(s)

3/4" x 3/4" square tubing as per Dwg D3266 Material: 304/316 SS tube .063" wall(

M304TS0.750W.065)

Batch: M 106409

FE 08/02/12

3.0 D2012117 Clevis



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2012-117 Clevis B31101

PD 08-02-12

4.0 D22323 Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2232-3 Hinge plate B35354

PD 08-02-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/4/2008 11:22:32 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY EC 130

Job Number: 37144B

Part Number: D3172041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D23273

Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2327-3

Bushing

B36697

PD 08-02-12

6.0

D31741

Mounting Lug



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 D3174-1

Mounting Lug

B24882

PD 08-02-12

7.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

B364181

PD 08-02-12

8.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 48.0000 sf(s)/Unit Total : 48.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

48sf M304EX0.75-16F

Expanded Metal

M107036

PD 08-02-15
~~08-02-12~~

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut Qty 4 D3166-1 as per Dwg D3172

2-Cut 3/4" x 3/4" square tubing as per Dwg D3172

3-Drill holes in D3172-3 as per Dwg D3172

FC 08/02/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/4/2008 11:22:33 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY EC 130

Job Number: 37144B

Part Number: D3172041

Job Number:



Seq. #:

Machine Or Operation:

Description:

4-Deburr & Remove all markings from material

5-Weld as per Dwg D3172 using Welding Table and corner Jig & D3172T1 Deburr as required

A/R SS Rod Batch M105524

08-02-19 (1)

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/02/19 (1)

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

08/02/19 (1)

12.0

POWDER COATING

POWDER COATING



M107005



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

08-02-20 (X)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

08-02-20

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

08-02-20

15.0

QC21

FINAL INSPECTION/W/O RELEASE



08.02.21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08.02.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

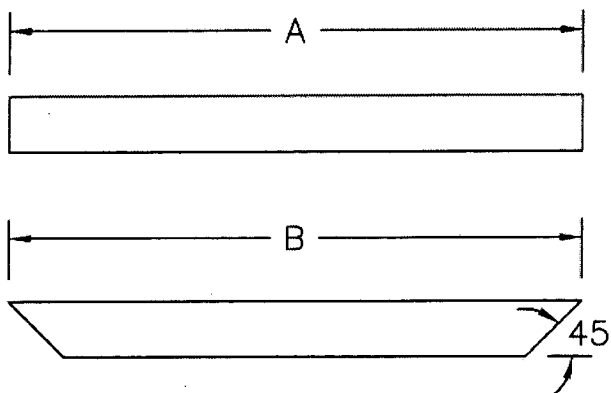


DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3172	REV. B SHEET 1 OF 3
DATE 03.01.07		TITLE BASKET BASE ASSEMBLY (EC130)	
A	02.12.02	NEW ISSUE	
B	03.01.07	ADD D3172-9 & D2012-117	

RELEASED
03.01.20

PARTS LIST FOR D3172-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3172-1	2	—	96.00	RIB
D3172-3	2	—	25.50	RIB
D3172-5	6	33.09	—	RIB
D3172-7	3	26.81	—	RIB
D3172-9	1	94.50	—	RIB
D2012-117	4	N/A	N/A	CLEVIS
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRKT
D2232-3	2	N/A	N/A	HINGE PLATE
D3166-1	4	N/A	N/A	RIB
D3174-1	8	N/A	N/A	MOUNTING LUG



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NO. 37144B

NOTES:

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
- 3) MESH MATERIAL: 3/4-16F EXPANDED SS
- 4) WELD PER DART QSI 004
- 5) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

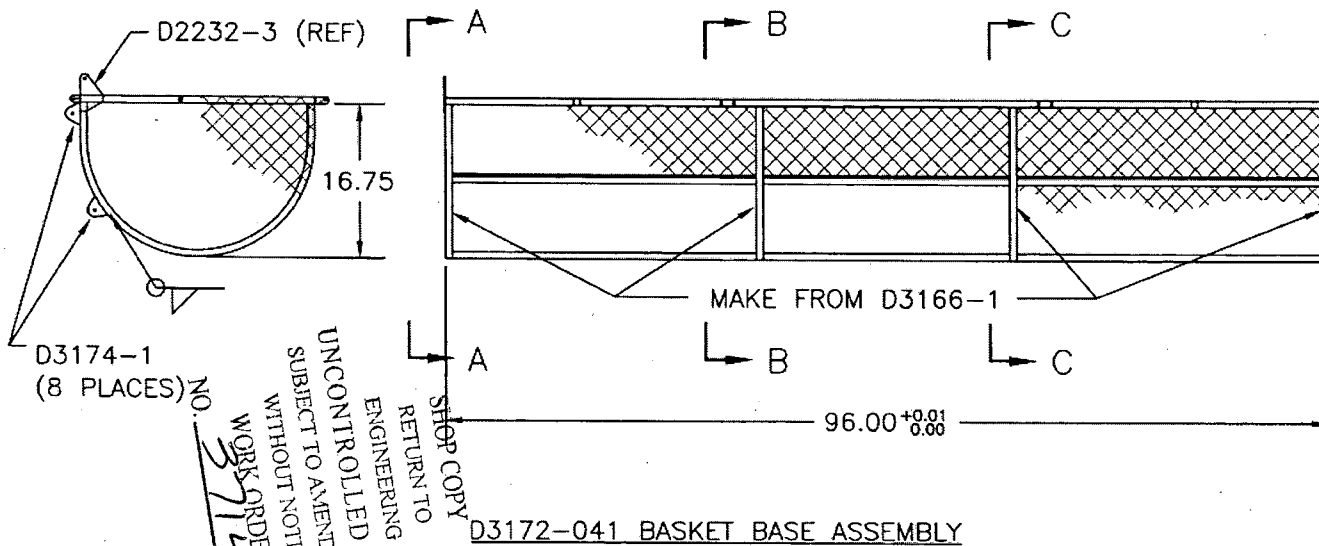
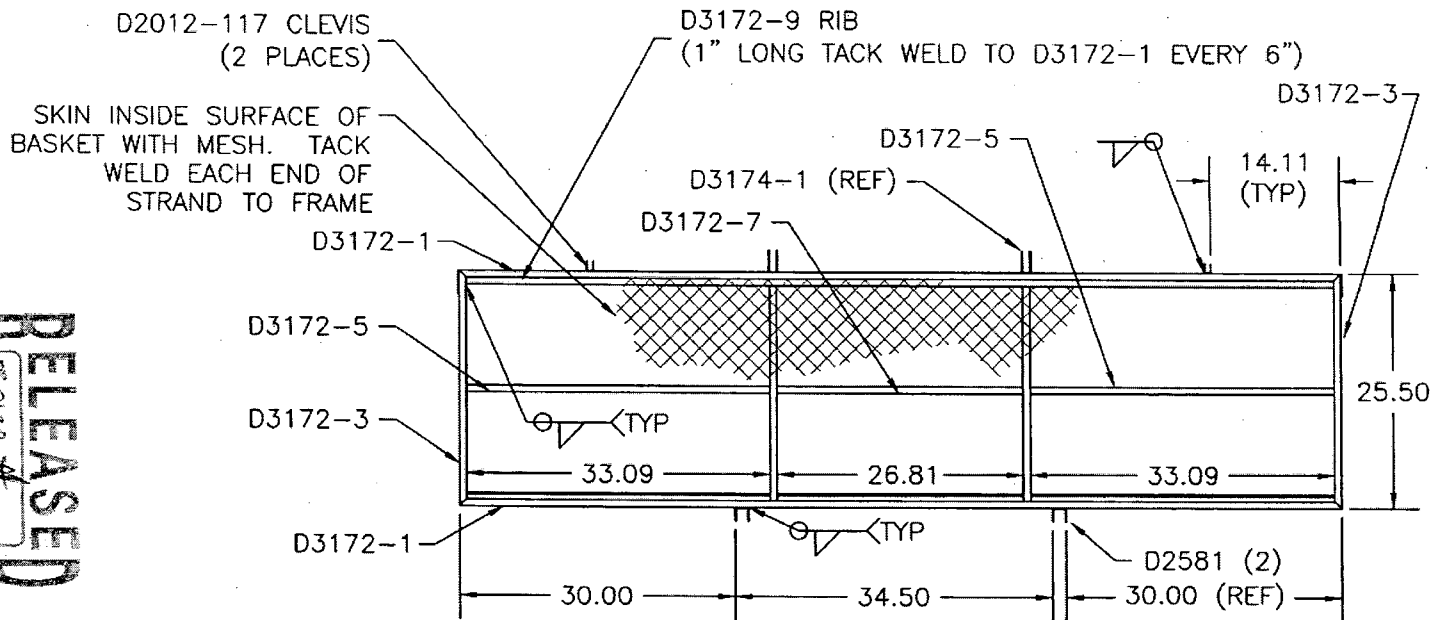
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DATE	03.01.07	DRAWING NO.	D3172	REV. B
TITLE	BASKET BASE ASSEMBLY (EC130)	SHEET 2 OF 3	SCALE	1:20

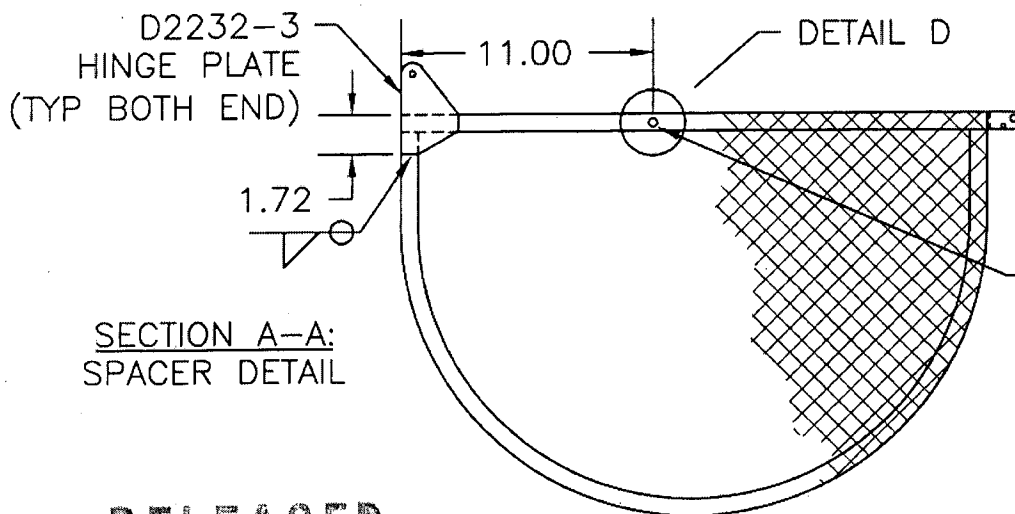


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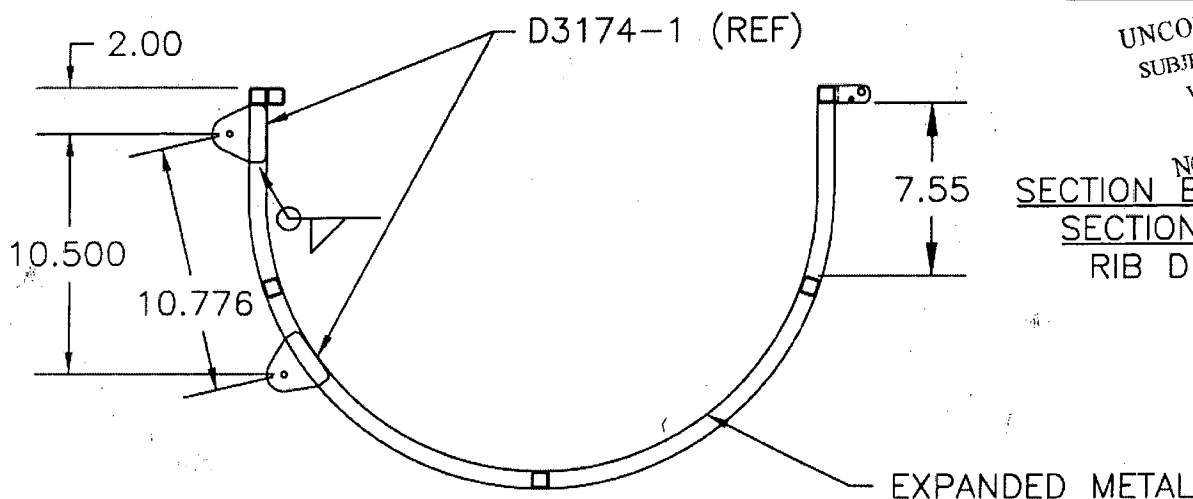
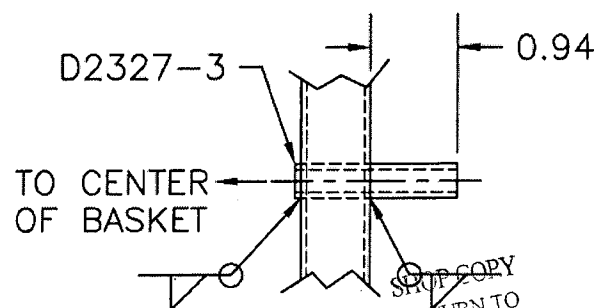
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03.01.20



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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3172	REV. B SHEET 3 OF 3
DATE 03.01.07		TITLE BASKET BASE ASSEMBLY (EC130)	SCALE 1:8



RELEASED
03.01.20



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